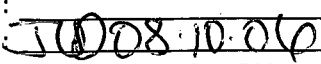











Date: Monday, 06/10/2008 11:44:22 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW MEDIUM BELL
Job Number	: 42462A		
Estimate Number	: 12129		
P.O. Number	:	Part Number	: D412729041
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: DSK 092 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 39424A	Material	:
Written By	:	Due Date	: 31/10/2008 Qty: 2 Um: Each
Checked & Approved By			
Comment	: Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL If D412-729-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-729-041 CHG003			
2.0	D27287	Label	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Label <u>22554</u>			
SAD 08/11/03			
3.0	D3233041	Wheel Assembly	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-041 Wheel Assembly <u>B42464</u>			
SAD 08/11/03			
4.0	D32331	Inside Washer	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-1 Inside Washer <u>37073</u>			
SS 08/10/14 K2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32333

Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer

370714

JS 08/10/14

6.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label

37078

Comp
won't take
Qty 5.

JS 08/10/14

7.0

D33093

Label



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label

39445

JS 08/10/14 x2

8.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment

39446 x2

JS 08/10/14

9.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly

37082

JS 08/10/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	D3332041	Pin Assembly
------	----------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly 37784

JS 08/10/14 (K2)

11.0	D3332043	Pin Assembly
------	----------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly 37059

JS 08/10/14 (K2)

12.0	D33331	Base Plate Panel
------	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate 31522

JS 08/10/14 (K2)

13.0	D33333	Sliding Plate
------	--------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate 39447x1 B42472

JS 08/10/14 (K2)

14.0	D33335	Rail
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:


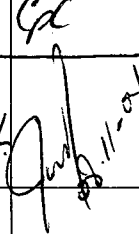
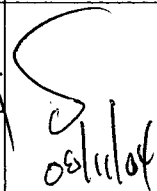
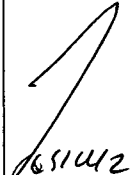
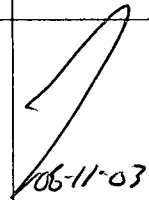
Qty Part Number Description Batch

4 D3333-5 Rail 39448x1 B42473 → 7

JS 08/10/14 (K2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-729-041 PAR #: N/A Fault Category: Prod Eng Coord. NCR: Yes No DQA: NA Date: 08-11-04
 Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: 08/11/20

NCR:42462A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-03	13.0	Upon Assy it was noticed that the threaded holes are not tapped all the way through. Missing 1.5 of the thread, ∴ bolts cannot go in. R.C: Machining error in program did not finish the threading. ∴ tapping.	 08/11/02	- Tap parts all the way through manually on this batch - Verify the program & have it tap the holes all the way through.	 08-11-04	 08/11/04	 08/11/02	 08-11-03

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 D33341 Wheel Shaft



Wheel Shaft

COMP
w/ 1/2
take steps



P16

Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft

37785X3

B042474

JS 08/10/14 (X2)

16.0 D33351 Short Spring



Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring

25925

JS 08/10/14 (X2)

17.0 D33353 Long Spring



Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring

39450

JS 08/10/14 (X2)

18.0 D33361 Jack



Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack

37786

JS 08/10/14 (X2)

19.0 AN960JD416 Washer



Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer

108827

JS 08/10/14 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-729-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08.11.04
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42462A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.11.03</u>	<u>15.0</u>	<u>Upon ASS'Y it was found that the slotted nut could not be installed due to insufficient threads on the shaft.</u> <u>R.C. Improper threading during machining.</u>	<u>[Signature]</u> <u>08/10/04</u>	<u>re-do threads.</u>	<u>SAD</u> <u>08/10/03</u>	<u>[Signature]</u> <u>08/11/04</u>	<u>[Signature]</u> <u>08/11/04</u>	<u>[Signature]</u> <u>08.11.03</u>

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span

M108200

JS 08/10/14 (12)

21.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span

16529

JS 08/10/14 (12)

22.0

HC29

5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof

M107524

JS 08/10/14 (12)

23.0

HC153

3/8"-24UNFx1.25" Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span

M109654 x 8

M107031 x 8

JS 08/10/14 (12)

24.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof

102150

JS 08/10/14 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation: Description :

25.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span 108200

JS 08/10/14 (K)

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span 108200

JS 08/10/14 (K)

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M10814

JS 08/10/14 (K)

28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span 102150

JS 08/10/14 (K)

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span 107031

JS 08/10/14 (K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Date: Monday, 06/10/2008 11:44:22 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 42462A

Part Number: D412729041

Job Number:



Seq. #: Machine Or Operation: Description :

30.0 113803 1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span 106512

SS 08/10/14 (X2)

31.0 516WC SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof 69236

SS

32.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

SS 08/11/04

08-11-04

33.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sasulox (X2)

34.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 42462A

8/11/4

34

35.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/04

Job Completion



208/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

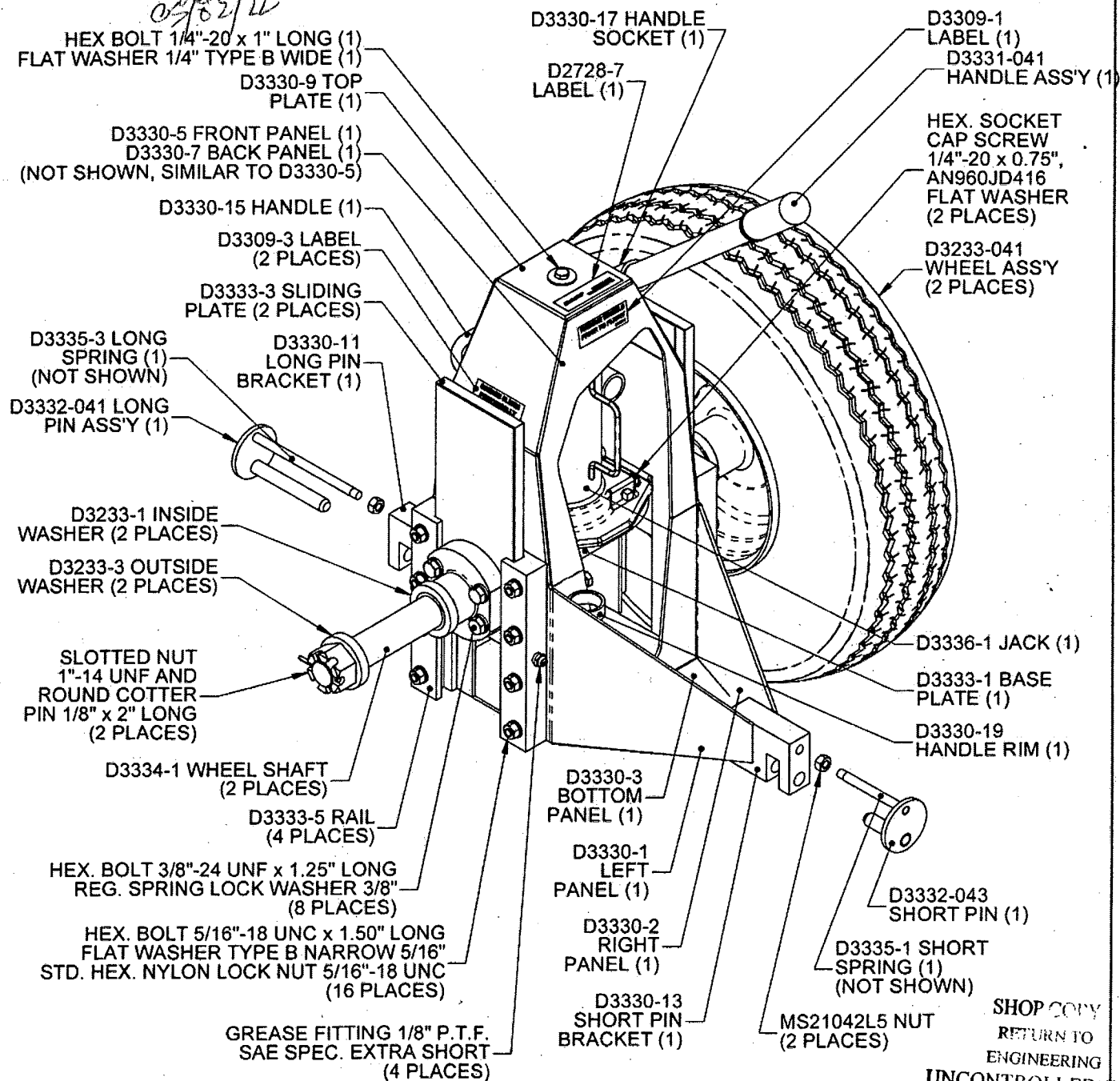
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE	05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED



NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
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